

Date: Tuesday, 11/29/2005 2:51:25 PM
User: Linda Lacelle

Process Sheet

SP lib

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLUG
Job Number : 25010
Estimate Number : 10512
P.O. Number : NIA Part Number : D26511
This Issue : 11/29/2005 S.O. No. : NIA Drawing Number : D2651 REV. B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : NIA Material : NIA
Written By : EST. KEVB ~~05/12/10~~ E.C. Due Date : 11/29/2005 Qty: 400 Um: Each
Checked & Approved By : SEE ABOVE DATE & USER
Comment : Created By Auto Work Order!!! Late - Some of the material cannot be made in time.

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar .500"



Comment: Qty.: 0.0875 f(s)/Unit Total : 34.9860 f(s)

Material: 6061-T6 (QQ-A-225/8) 0.500" Dia

(M6061T6R0500)

Batch:

M15211-9'
M16991-24.25

gnd 05/12/10 400

Tools:

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Bar: 0.62" Long

Tools:

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA219 and Dwg D2651

2- Deburr

Identify as D2651-1

gnd 05/12/11 400

Tools:

4.0 A QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Tools:

5.0 Small Lab.

Deburr as per Dwg D2651

FF

05/12/16

380

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PLUG

Job Number: 25010

Part Number: D26511

Job Number:



Seq. #:

Machine Or Operation:

Description :

~~5.0~~
4.0 B

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 05.12.12

400
380

Tools:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 05/12/20 300

Tools:

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Only larger section necessary)

FC 06.02.20

Tools:

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ML 06.02.22

Tools:

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP

ML 06.02.22

380

Tools:

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/02/23

Tools:

Job Completion



u 06-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Proj Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

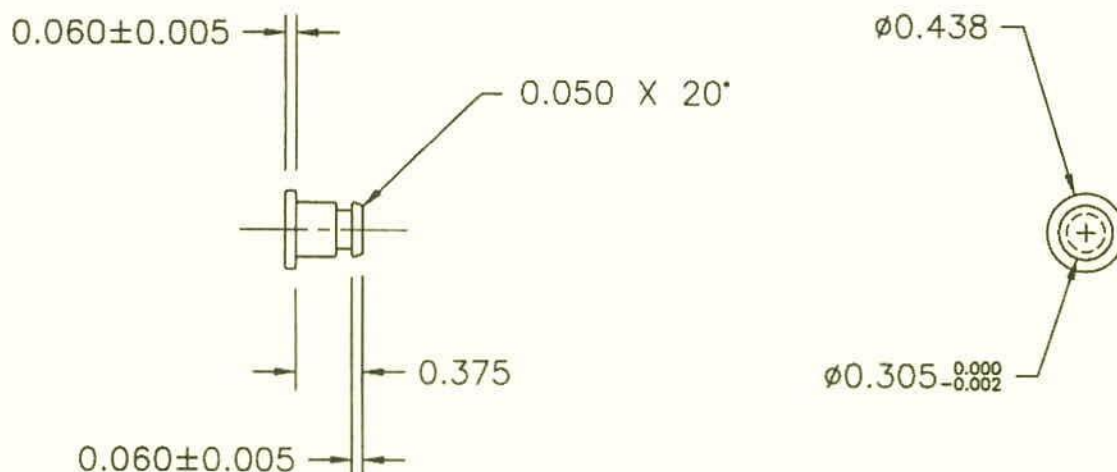
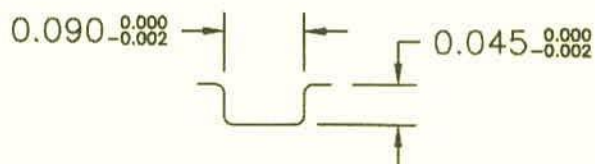
NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED

03.12.19

D2651-1 PLUG:GROOVE DETAIL (SCALE 5:1)D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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